

Date: Friday, 23/05/2008 12:41:50 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|------------------------------------|---|---------------------------|-------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | STRUT |
| Job Number : | 39461 | | |
| Estimate Number : | 11221 | | |
| P.O. Number : | | Part Number : | D3350041 |
| This Issue : | 23/05/2008 | Drawing Number : | D3350 REV A |
| Prsht Rev. : | NC | Project Number : | N/A |
| First Issue : | // | Drawing Revision : | A |
| Previous Run : | 36248 | Material : | |
| Written By : | | Due Date : | 10/06/2008 |
| Checked & Approved By : | JUO 08.5.23 | Qty: | 10 Um: Each |
| Comment : | Est:B 05.07.11 Powder Coat now done after assembly KJ/JLM | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B0750X00750 | 6061-T6 Bar .75" x .75" |
|-----|--------------------|-------------------------|



Comment: Qty.: 1.3234 f(s)/Unit Total : 13.2342 f(s)

6061-T6 Bar .75" x .75"

Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)

(M6061T6B0.750x00.750)

Identify for D3350-1

Batch: M103387

ML 08/06/21

16

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW

Cut blank: 0.750" x 0.750" x 15.00" long

ML 08/06/21

16

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3350-1 as per Folio FA496 and Dwg D3350

Identify as D3350-1

JL/ML 08/06/23

10

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL/ML 08/06/23

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

ML 08/06/24

10

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 23/05/2008 12:41:50 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 39461

Part Number: D3350041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble and Deburr

J.L 08/06/24

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

M-L 08/06/24

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/06/24 (10)

9.0

D23245

Strap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Strap
Pick:
Qty Part Number Description Batch
2 D2324-5 Strap B 39152 (5x)

08/06/24 B 37631 (3x) 339639 (12x)

10.0

AN312A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Bolt
Pick:

Qty Part Number Description Batch
2 AN3-12A Bolt M106605

08/06/24

11.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)
Washer
Pick:
Qty Part Number Description Batch
4 AN960JD10 Washer M108077

08/06/24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 23/05/2008 12:41:50 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 39461

Part Number: D3350041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------|
| 2 | MS21042L3 | Nut (or -3) | M10 7665 |

CP 08/06/24

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3350.

Identify as D3350-041 and batch number using a fine point permanent marker

CP 08/06/24 (10)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/24 (10)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 107925

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M 35
320°
2:05

BL 08-06-26 (10)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 08/06/26 (10K)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 271

8/6/27

(10x)

SD

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/01

Job Completion



MF 08-06-30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

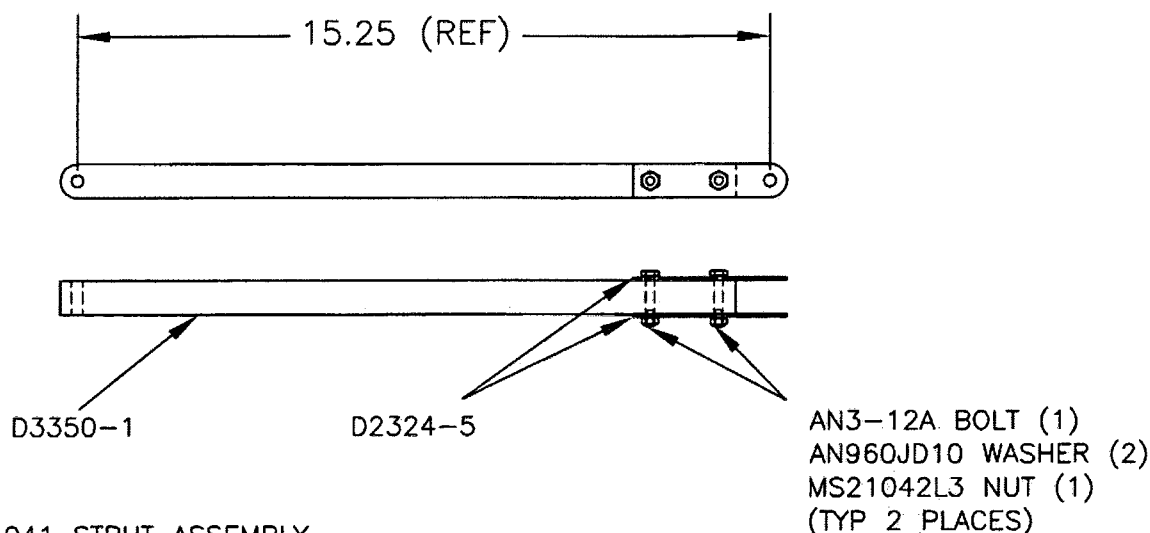
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

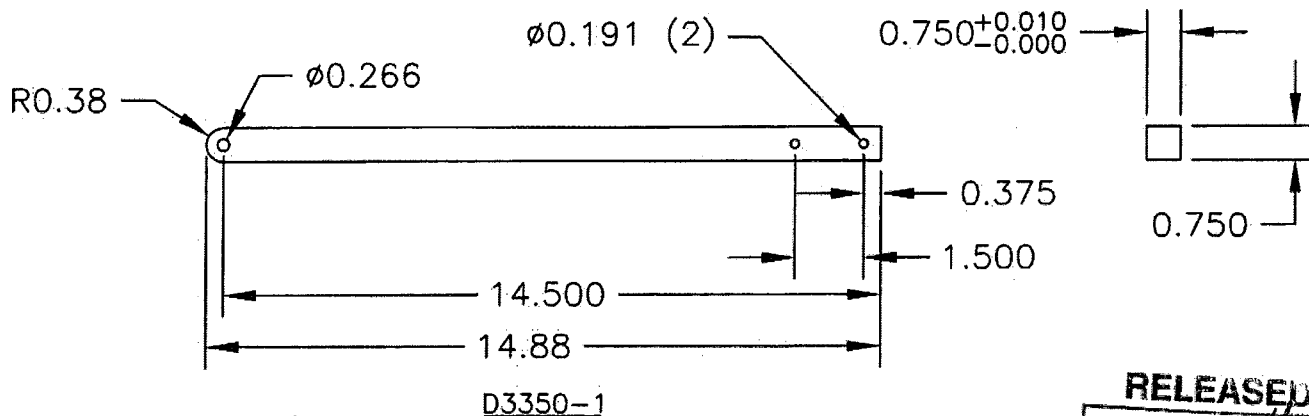


| | | | |
|------------------|----------------|---|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED PH | APPROVED PH | DRAWING NO. D3350 | REV. A SHEET 1 OF 1 |
| DATE 04.11.12 | | TITLE STRUT | SCALE 1:4 |
| A | 04.11.12 | NEW ISSUE | |



D3350-041 STRUT ASSEMBLY

- 1) IDENTIFY WITH DART P/N D3350-041 USING FINE POINT PERMANENT INK MARKER



D3350-1

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

RELEASED
04.12.16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39461

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